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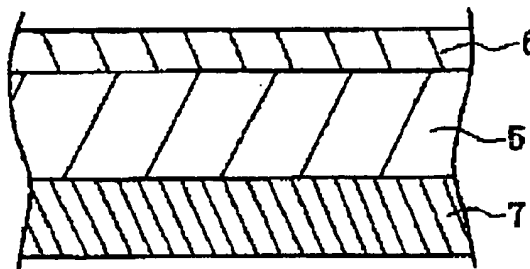
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TITLE : PRODUCTION OF ALUMINUM ALLOY
BRAZING SHEET FOR HEAT
EXCHANGER



ABSTRACT : PURPOSE: To produce an Al alloy brazing sheet for a heat exchanger having excellent performance by cladding both faces of a core material made of an Al alloy with a brazing filler metal made of an Al alloy and a sacrificial material made of an Al alloy having a specified compsn., subjecting it to hot rolling and process annealing under specified conditions and thereafter executing cold rolling.

CONSTITUTION: One side of the core material 5 made of a high strength Al alloy contg., by weight, 0.2 to 1.5% Si, 0.05 to 1.5% Cu and 0.05 to 2.0% Mn or furthermore contg. one or \geq two kinds among Mg, Cr, Zr, Ti and Ni, and the balance Al is clad with a brazing filler metal 6 made of an Al alloy such as a JIS-4043 alloy, and the other side is clad with an Al alloy sacrificial material 7 contg. 0.5 to 6.0% Zn and 0.8 to 2.5% Mg or furthermore contg. specified small amounts of one or more kinds among Mn, In and Sn. At the time of subjecting this clad material to hot rolling and cold rolling to work into a sheet material, in the process of the cold rolling, it is subjected to process annealing of holding the temp. at 400 to 500°C for 1 to 60sec and executing cooling at $\geq 10^\circ\text{C}/\text{min}$ cooling rate and is thereafter subjected to cold finish rolling to produce an Al alloy brazing sheet.

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